	^ /		:					*		
	1511		to income in	<u>.</u> w	·	·		Shyp	Die ?	1
Work Order ID November-27-13 7:45.				719*				<i></i>	· · · · · · · · · · · · ·	Page 1
Item ID: D3021 Revision ID:	1-043	. 1886 9 9 9 1 8 1 9 9 9 9 9 9 9 9 9 9 9 9 9 9	Accept	*N900	040	1100)* s	etup Star	' *N	S1*
· • •	Assembly	•						Stop	*N	S2*
Start Date: 11/27/ Required Date: 12/11/	~ •	*1* *1*		Cust Item I Customer:	ID:					
Référence:					<u> </u>		· R	tun Star	' ^t *NI	D4*
1	ess Plan: MC5				ate:			Stoj	ν Ν*	R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr		· · · · · · · · · · · · · · · · · · ·							
D3021	В									13-16
*100 *100*	Large Fab		0.00				Ĵ			1
Large Fab Large Fab	Memo	as per Dwg D3021	0.00							
24.50 1 40		e as per Dwg D3021 using	DT8622							
	3-Deburr	o and here at the angle of the angle of							•	
	4-Weld stu	d and end cap as per Dwg I 0 Rod Batch:	23021 QS1004							
110	QC9- Inspect visual pe	r QSI004- Fusion Welds	0.00							
11 1 0 QC Quality Control	Memo		0.00) 13	>-12-03	· • • !

DQA:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE										
QA Closed:			Date:			WORK ORDER NON-	-((JINFUI	RIVIAINCE / U		Wo	ork Order up	date only	AEROSPACE		
Morle Orde						DISPOSITION				AGAINST I	DEI	PARTMENT,	PROCESS			
Work Orde	er:					Rework	ı		Skid-tube	Crosstube			Water Jet	Engineering		
Part N	lo.					Scrap			Machining	Small Fab	=	Pro	d. Eng. Coor.	Quality		
	•••					Use-as-is			noforming	Finishing			e/Packaging	Other		
NCR I	۱o.		······		<u></u>	Suspected Unapproved			Large Fab	Composite		•	Supplier			
Root					Desc	ription of work order update	1	nitial	Action			Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	QC Inspector		
Design														1		
Doc/Data																
Equip/Tooling																
Handling/Pre										•						
Material									•							
Operator							l									
Offset/Setup			ŀ		ŀ											
Process							١									
Supplier]													
Training		i i		į	:											
Transport																
Unapproved			<u> </u>				<u> </u>		<u> </u>							
							FAI	ULT CA	TEGORY							
Landi	ng (1			_	General		1		г		1		-		
	<u> </u>	Bending			<u> </u>	Bend	<u> </u>	1	Program			Outside Dim	<u> </u>	Pressure/Forced		
	<u> </u>	Centre No	ot Concer	ntric	<u> </u>	BOM/Route	_	Grain				Over/Under	<u> </u>	Set-up ,		
	ļ	Cracks			ļ	Broken/Damage/Defect	<u> </u>	Hardwa				Part Incorred	 	Temperature/Cure		
	Crimp/Kink/Ripple/Wave				_	Burrs	<u> </u>	1 1	ion Incomplete/L	· •	_	Part Lost/Mi	_	Weld		
	Cuffs				ļ	Contamination		4	tions Incomplete	- F		Part Moved		Wrong Stock Pulled		
					\vdash	Countersink	—	-	gned/off center	ļ	_	Positioned V	_	¬		
					<u> </u>	Cut Too Short	<u></u>	Mislab				Power Loss/	Surge	Other		
					L	Drawing	\vdash	Misrea					****			
					<u> </u>	Drill Holes	L	Off-set				•				
Turning Sequence						Finish	Out of Calibration									
Wave/Twist in Tube						Fit/Function		Out of Sequence								

Work Orde November-27-13				*109	9719*		· 				Page 2
Item ID: Revision ID:	D3021-043			Accept	*N900	040	100)* s	etup Sta	1 77	S1*
- The state of the	Tube Assembly	y							Sto	p *N	S2*
Start Date:	11/27/13	Start Qty: 1.00	*1*		Cust Item I	D:					
Required Date:	12/11/13	Req'd Qty: 1.00	*1*		Customer:						
Reference:			•								
Approvals:	Process Pla	n:	Date:	Tooling:	Da	ate:		R	Run Sta	7	R1*
	QC:		Date:		Da	ate:			Sto	*N	R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		QC5- Inspect part comple	eteness to step on W/O	0.00							DAS
120) 13-1	2-03	9
QC		Memo		0.00		٠					
*Quality Control											
130		Grey Sandtex(Ref:4.3.5.6		0.00				e.	-		3 DAS
130 Powdercoat		•	~ 6	0.00					-P	13-17	グ <u>3</u> 4 9-89
Powder Coating		Memo *** MASK 1	THREAD PRIOR TO PO						,		3-08
i i		START TIM OVEN TEM	IE: 10. 20 3200 PERATURE: 3200 PERAT	_	DAS 27						
140		QC3- Inspect Part Finish		0.00	9-89 }			.4			
140				121	12/03			1			
QC		Memo		0.00	· + ()				. <u> </u>		

Memo

Quality Control

DQA:			Date:										TRACT	
						WORK ORDER NON-	-CC	NFO	RMANCE / UPDATE				AEROSPACE	
QA Closed:			Date:							W	ork Order up	date only		
Work Orde	ır.					DISPOSITION			AGAINST	DE	PARTMENT,	/PROCESS		
Work Orac			•			Rework			Skid-tube Crosstube]	Water Jet	Engineering	
Part N	lo.					Scrap			Machining Small Fab	-	Pro	d. Eng. Coor.	Quality	
	•					Use-as-is			noforming Finishing		1	re/Packaging Other		
NCR N	lo.		•			Suspected Unapproved			Large Fab Composite					
Root					Desc	ription of work order update	Ī	nitial	Action	Action				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng Description			Date	Verification	QC Inspector	
Design						•						:		
Doc/Data														
Equip/Tooling											ļ			
Handling/Pre											İ			
Material	$H \mid I \mid I$													
Operator		-												
Offset/Setup		_												
Process									·					
Supplier														
Training Transport		l												
Unapproved	-													
		l	l	<u> </u>	!		FAI	ULT CA	TEGORY				. I	
Landi	ng (Gear				General								
;	_	Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced	
		Centre No	ot Concer	ntric		BOM/Route		Grain	-	Г	Over/Under	tolerance	Set-up	
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ci	Temperature/Cure	
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld	
		Cuffs				Contamination		Instruc	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled	
		Crushing				Countersink		Misali	gned/off center		Positioned V		_	
		Heat Trea	at			Cut Too Short		Mislab			Power Loss/	Surge	Other	
		Inspectio	n Strip in	Tube		Drawing		Misrea	d					
		Marks/Ch	natter			Drill Holes		Off-set						
		Turning S				Finish	Out of Calibration							
Wave/Twist in Tube						Fit/Function		Out of	Sequence					

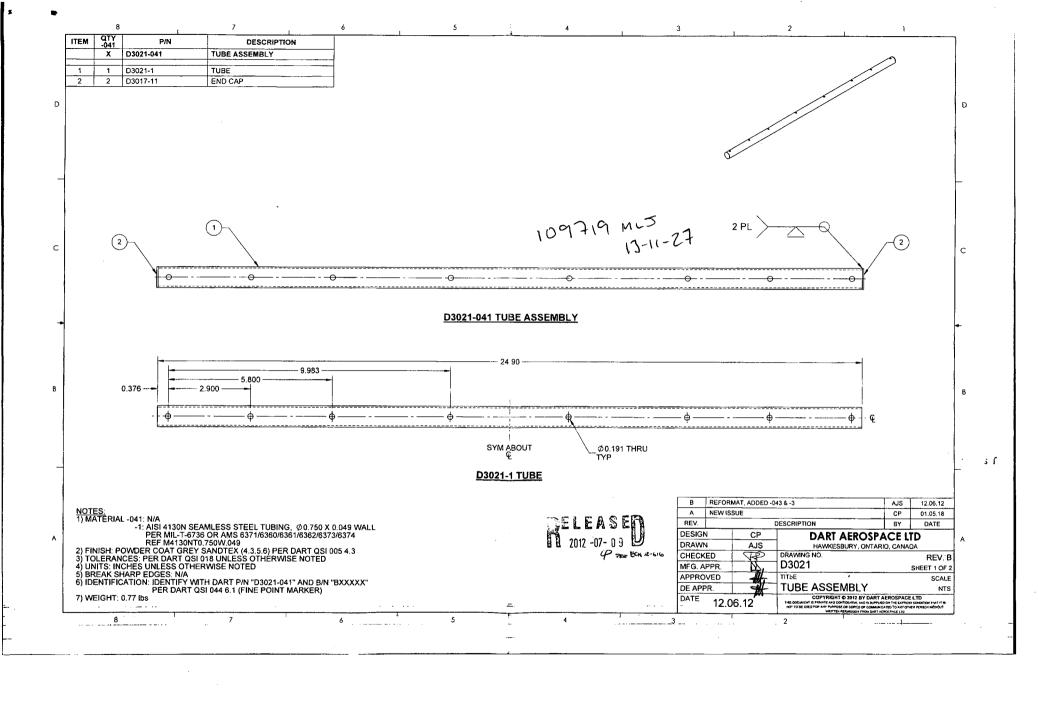
Work Orde November-27-1.				Page 3					
Item ID: Revision ID: Item Name:	D3021-043 Tube Assembl	y		Accept	*N900	040100)* Setup	Start Stop	*NS1* *NS2*
Start Date: Required Date: Reference:	11/27/13 12/11/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item II Customer:) :			
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		te:	Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II 150 *150* Packaging Packaging)	Operation Description Identify as per dwg & St Memo	ock Location	Set Up/ Run Hours 0.00	Tool ID	Tool # Plan Code	Accept Re Qty Qt		Reject Insp. Number Stamp
*160 *160* QC Quality Control		QC21- Final Inspection -	Work Order Release	0.00			13/12/	4 8	9.88

W 13-62-04

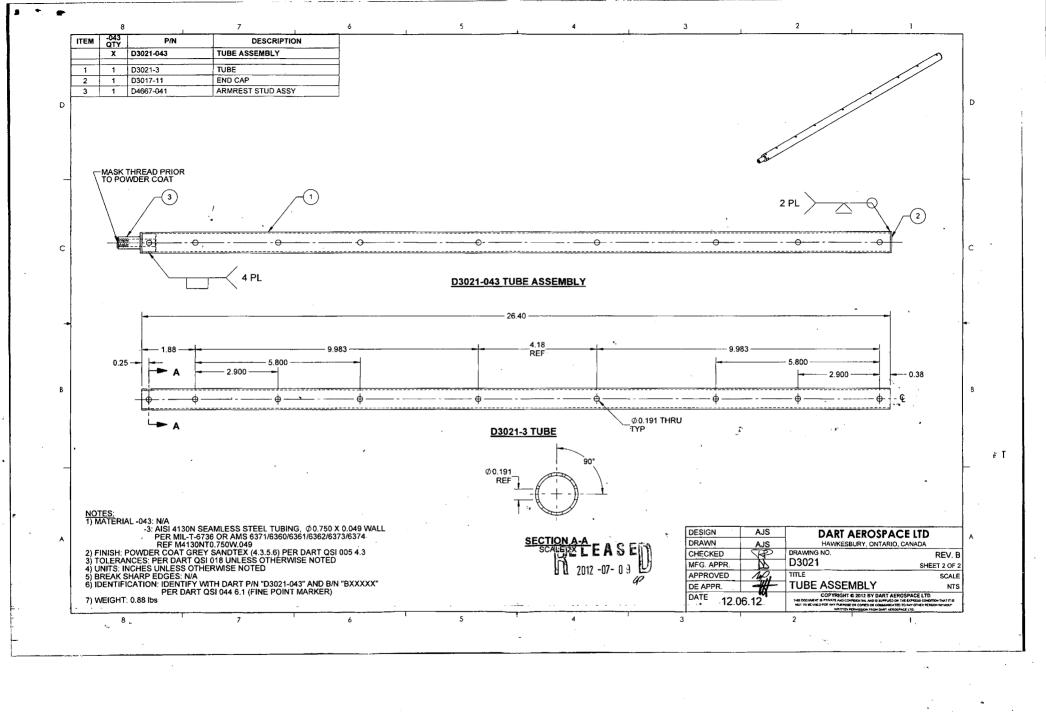
DQA:			Date:										•	
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE					AEROSPACE
QA Closed:			Date:							W	ork Order up	date only		
 Work Ord	er:					DISPOSITION			AGAINST	DE	PARTMENT	PROCESS		
		· · · · · · · · · · · · · · · · · · ·	,			Rework			Skid-tube Crosstube		1	Water Jet	\neg	Engineering
Part i	lo.					Scrap		1	Machining Small Fab	_	Pro	d. Eng. Coor.	T	Quality
	•					Use-as-is		Thern	noforming Finishing		Rec/Store/Packaging			Other
NCR f	١ο٠ ِ					Suspected Unapproved			Large Fab Composite]			
Root					Desci	ription of work order update	1	nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	Chief Eng Description			Date	Verification		QC Inspector
Design														
Doc/Data														
Equip/Tooling				;										
Handling/Pre													ı	
Material														
Operator														
Offset/Setup													1	
Process							1							
Supplier														
Training							ļ							
Transport														
Unapproved	L	<u> </u>	<u> </u>		<u> </u>		<u> </u>							
							FA	ULT CA	regory					
Landi	ng (1				General	_]		_	٦	. г	_	D /F 1
		Bending			\vdash	Bend	L	4	Program	-	Outside Dim	-	\dashv	Pressure/Forced
	<u> </u>	Centre No	ot Concer	ntric	-	BOM/Route	_	Grain		Ŀ	Over/Under	H-	-	Set-up
	_	Cracks	. I. /D: I.			Broken/Damage/Defect	<u> </u>	Hardwa		-	Part Incorred	<u> </u>		Temperature/Cure
	Crimp/Kink/Ripple/Wave				-	Burrs	\vdash	1	ion Incomplete/Unqualified	H	Part Lost/Mi	ssing		Weld
	Cruching					Contamination	_	-1	tions Incomplete/Unclear	\vdash	Part Moved	L		Wrong Stock Pulled
	<u> </u>	Crushing			-	Countersink	\vdash	- 1	gned/off center	\vdash	Positioned V			Othor
	-	Heat Trea		Tuka	_	Cut Too Short	-	Mislabe		L	Power Loss/	ourge [Other
i	_	Inspection	•	iupe	-	Drawing Drill Holos	-	Misread						
	<u> </u>	Marks/Ch			 	Drill Holes	Off-set							
Turning Sequence					-	Finish	Out of Calibration Out of Sequence							
	Wave/Twist in Tube					Fit/Function	I	JOUT OF	Sequence					

Picklist Print Page 1 November-27-13 7:45:10 AM Work Order ID: 109719 *109719* D3021-043 Parent Item: *D3021-043* Parent Item Name: Tube Assembly **Start Date:** 11/27/13 Required Date: 12/11/13 Start Qty: 1.00 Required Qty: 1.00 IPP REV:A 12.06.11 NEW ISSUE DD VERF:EC Comments: Component Item ID/ Last Route Unit of Replacement Mfg/ Primary Qty Date Status Item Name Item Location Location Seq ID Measure Hand Item ID Purch Issued Issued Otv D3017-11 100 Manufactured No Each 70.0000 *D3017-11* ** Location Loc Qty Loc Code WA001 70 104954 30 106668 40 D4667-041 100 0.0000 Manufactured Each No 13-12-02 ** *D4667-041* Armrest Stud Assembly M4130NT0.750W.049 100 272.6252 Purchased 2.325 109720 *M4130NT0 750W 049* ** 4130 RD Tube .750 x.049W Location Loc Code Loc Qty MAT033 272.6251893 123339 2.1217893 125252 12.7164 125313 91.614 m127111 166.173

DQA:			Date:												
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UP		ork Order up	date only	AEROSPACE		
Work Orde	\r.					DISPOSITION				AGAINST DI	PARTMENT	PROCESS			
Work Orde	٠.					Rework	ı		Skid-tube	Crosstube	1	Water Jet	Engineering		
Part N	۱o. ِ					Scrap		Machining Small Fal			4	d. Eng. Coor.	Quality		
NCR I	۱o. ِ					Use-as-is Suspected Unapproved	pected Unapproved Large Fab Compo			Finishing Composite					
Root					Desci	ription of work order update	ı	nitial	Actio	on	Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector		
Design															
Doc/Data							İ								
Equip/Tooling												:			
Handling/Pre															
Material											,		1		
Operator							1								
Offset/Setup															
Process			<u>'</u>				ŀ								
Supplier															
Training			1												
Transport															
Unapproved															
							FA	ULT CA	TEGORY						
Landi	ng (Gear				General									
		Bending				Bend		Folio/i	Program		Outside Dim	ensions	Pressure/Forced		
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up		
		Cracks				Broken/Damage/Defect	Г	Hardwa	are		Part Incorre	cí 🗌	Temperature/Cure		
	Г	Crimp/Kink/Ripple/Wave Burrs					Г	Inspect	tion Incomplete/Un	qualified	Part Lost/Mi	ssing	Weld		
	Г	Cuffs						Instruc	tions Incomplete/U	nclear	Part Moved		Wrong Stock Pulled		
		Crushing				Countersink		Misali	gned/off center	Γ	Positioned V	Vrong	_		
		Heat Trea	at			Cut Too Short		Mislab	eled		Power Loss/	Surge	Other		
		Inspectio	n Strip in	Tube		Drawing		Misrea	d		-				
		Marks/Ch				Drill Holes		Off-set	:						
		Turning S				Finish		Out of	Calibration						
		Wave/Tw				Fit/Function		Out of	Sequence						



DQA:			Date:													
					WORK ORDER NON-CONFORMANCE / UPDATE											
QA Closed:			Date:							Wo	ork Order up	date only				
						DISPOSITION			AGAINST	DE	PARTMENT	PROCESS				
Work Orde	er: .						.						_	<u>.</u> \square		
						Rework			Skid-tube Crosstube		Dua	Water Jet	\dashv	Engineering		
Part I	NO.					Scrap		ļ.	Machining Small Fab moforming Finishing			d. Eng. Coor. e/Packaging	\dashv	Quality Other		
NCR I	No.					Use-as-is Suspected Unapproved		merr	moforming Finishing Large Fab Composite		nec/3to	Supplier	ᅥ			
NCKI	١٠.					Suspected Onapproved	J		raige rab Composite							
Root					Desc	ription of work order update		nitial	Action		Sign &					
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification		QC Inspector		
Design																
Doc/Data													1			
Equip/Tooling																
Handling/Pre							l									
Material																
Operator											•					
Offset/Setup																
Process																
Supplier	<u> </u>			l			Ì									
Training																
Transport	<u> </u>															
Unapproved	L				<u> </u>			= 00	TECODY			<u></u>		<u> </u>		
							FA	ULI CA	TEGORY							
Landi	_	•				General Bend		احمانه را	Program		Outside Dim	ansions [-	Pressure/Forced		
1	┢	Bending Centre No	nt Camaa	atria	\vdash	BOM/Route	-	Grain	riogiani	\vdash	Over/Under		_	Set-up		
	<u> </u>	Cracks	ot concer	itric	\vdash	Broken/Damage/Defect	-	Hardwa	aro	<u> </u>	Part Incorre	- F		Temperature/Cure		
	 	Cracks Crimp/Kir	ak/Pinnla	/\M2va	-	Burrs	\vdash	4	tion Incomplete/Unqualified	 	Part Lost/Mi	⊢		Weld		
	\vdash	Cuffs	ik/itippie	., wave	<u> </u>	Contamination		1 '	tions Incomplete/Unclear	H	Part Moved	-	_	Wrong Stock Pulled		
	H	Crushing			Countersink		4	gned/off center	一	Positioned V	L Vrong		1			
·		Heat Trea				Cut Too Short		Mislab			Power Loss/			Other		
	\vdash	Inspectio		Tube		Drawing	\vdash	Misrea			J : =====	· [
	\vdash	Marks/Ch				Drill Holes		Off-set								
		Turning S				Finish		4	Calibration			·····				
Wave/Twist in Tube						Fit/Function	Out of Sequence									



DQA:			Date:						•				TRAC
0.46			D-4			WORK ORDER NON-	-CC	ONFO	RMANCE / UPD		ork Order up	odata anku 🗀	AEROSPACE
QA Closed:			Date:		*					V	ork Order up	date only	
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
	-				_	Rework			Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•				_	Use-as-is			noforming	Finishing		e/Packaging	Other
NCR N	lo.					Suspected Unapproved			· H	Composite		Supplier	
												•	
Root					Desci	ription of work order update	Initial		Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descript	tion	Date	Verification	QC Inspector
Design	_												
Doc/Data	_												·
Equip/Tooling													
Handling/Pre						•							
Material		4											
Operator		-											
Offset/Setup		1					1						
Process			 										
Supplier Training													,
Transport											-		,
Unapproved													
			4				FAI	ULT CA	TEGORY		•		
Landi	ng (Gear				General		· · · · · · · · · · · · · · · · · · ·					
}		Bending				Bend		Folio/f	Program		Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ci	Temperature/Cure
						Burrs		Inspect	tion Incomplete/Unqu	ualified	Part Lost/Mi	issing	Weld
1	Cuffs Contamination							4	tions Incomplete/Und	clear	Part Moved		Wrong Stock Pulled
		Crushing				Countersink		4	gned/off center	<u> </u>	Positioned V		7
		Heat Trea				Cut Too Short		Mislab		L	Power Loss/	Surge	Other
		Inspection		Tube		Drawing	_	Misrea					
	<u> </u>	Marks/Ch				Drill Holes	_	Off-set					
	<u> </u>	Turning S				Finish	Out of Calibration						
		Wave/Tw	ist in Tub	эe	ł	Fit/Function	1	Out of	Sequence				